

Date: Monday, 3/19/2007 4:35:20 PM
 User: Kim Johnston

Process Sheet

| | | | |
|-----------------------|--|------------------|-----------------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : OH-58 SKIDTUBE |
| Job Number | : 31292 | | |
| Estimate Number | : 11650 | | |
| P.O. Number | : <i>N/A</i> | Part Number | : D058672012 |
| This Issue | : 3/19/2007 S.O. No. : <i>N/A</i> | Drawing Number | : IIN D058-672 REV C |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : <i>N/A</i> Type : LANDING GEAR | Drawing Revision | : C |
| Previous Run | : 31291 | Material | : <i>N/A</i> |
| Written By | : <i>[Signature]</i> | Due Date | : 4/10/2007 Qty: 1 Um: Each |
| Checked & Approved By | : <i>[Signature] 07.03.20</i> | | |
| Comment | : Est Rev: G 02.06.27 Re-format; CHG002 (MPP 2251); ECN 258K J Est Rev: H 07-03-08 As per IIN D058-672 Rev C jlm | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|----|------------------|
| 1.0 | DC | DOCUMENT CONTROL |
|-----|----|------------------|



Comment: DOCUMENT CONTROL

Photo Copy Blue files and Type Labels as per PPP D058-672-012 CHG003

KS 07.03.26

| | | |
|-----|--------|-------------------------|
| 2.0 | 31292A | OH-58 SKIDTUBE ASSEMBLY |
|-----|--------|-------------------------|

Comment: Sub-Component 1 D058-672-041 OH-58 SKIDTUBE ASSEMBLY *R31292A*

| | | |
|-----|-------------|-----------------------|
| 3.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

| | | |
|-----|--------|------------------|
| 4.0 | D29332 | 206 Saddle Right |
|-----|--------|------------------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

| | | |
|-----------------|-------------|---------------|
| Qty Part Number | Description | Batch |
| 2 D2933-2 | Saddle | <i>B29233</i> |

| | | |
|-----|--------|-----------------------|
| 5.0 | D29322 | 206 Saddle Right side |
|-----|--------|-----------------------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

| | | |
|-----------------|-------------|--------------------|
| Qty Part Number | Description | Batch |
| 2 D2932-2 | Saddle | <i>B29233 (1X)</i> |

*B29231 (1X)**D058-672-043*Batch: *B31131*

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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Date: Monday, 3/19/2007 4:35:20 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OH-58 SKIDTUBE

Job Number: 31292

Part Number: D058672012

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2934

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D2934

Saddle Spacer

B30451 - ✓ ✓

7.0

D2935

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D2935

Saddle Spacer

B30946 - ✓ ✓

8.0

AN341A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

8 AN3-41A

Bolt

M103395 - ✓ ✓

9.0

D2652

Bushing



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch =

16 D2652

Bushing

B29332 - ✓ ✓

10.0

AN960JD10

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

8 AN960JD10

Washer

M103962 - ✓ ✓

11.0

MS21042L3

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

8 MS21042L3

Nut (or -3)

M102658 - ✓

Pc 7/7/27

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Date: Monday, 3/19/2007 4:35:20 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OH-58 SKIDTUBE

Job Number: 31292

Part Number: D058672012

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

AN510A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN5-10A Bolt M102328 ✓

13.0

AN512A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN5-12A Bolt M102658 ✓

14.0

AN960JD516

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 AN960JD516 Washer M15927 ✓

15.0

AN46A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN4-6A Bolt M102115 ✓

16.0

AN960JD416

Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

24 AN960JD416 Washer M102929 ✓

17.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

PC/14/07

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OH-58 SKIDTUBE

Job Number: 31292

Part Number: D058672012

Job Number:



Seq. #:

Machine Or Operation:

Description:

12 *PA* 12-MS21042L4 Nut (or -4) *M10 3714 -*
18.0 D2712 Set Screw



Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

10 D2712

Set Screw

B 26481 -

19.0 D2968043

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D2968-043

Tow Ring

B 29353 -

20.0 AN960JD1016

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Washer

Batch:

M5519 -

21.0 AN9704

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 AN970-4

Washer

M10 3344 -

Rec 7/7/27 (1)

22.0 MS210424

USE MS21042L4



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

N/A USE MS21042L4

Batch:

AT

N/A PA

23.0 QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

Rec 7/24/27 (1)

C207104(270)

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/04/30
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Date: Monday, 3/19/2007 4:35:20 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OH-58 SKIDTUBE

Job Number: 31292

Part Number: D058672012

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D058-672-012

Location:

PPP Rev:

REV B

07/04/270

25.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/04/30

Job Completion



07-04-30

31292A

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

5.0 PARTS LIST

| Item | 672 -011 | 672 -012 | 672 -013 | 672 -014 | 672 -041 | 672 -043 | Part Number | Description |
|------|-------------|-------------|-------------|-------------|-------------|-------------|--------------------------|---------------------------|
| | X | | | | | | D058-672-011 | SKIDTUBE INSTALLATION, LH |
| | | X | | | | | D058-672-012 | SKIDTUBE INSTALLATION, RH |
| | | | X | | | | D058-672-013 | SKIDTUBE INSTALLATION, LH |
| | | | | X | | | D058-672-014 | SKIDTUBE INSTALLATION, RH |
| | 1 | 1 | 1 | 1 | X | | D058-672-041 | REPLACEMENT SKIDTUBE |
| | 1 | 1 | 1 | 1 | | X | D058-672-043 | GROUND HANDLING KIT |
| 1 | | | | | 1 | | D2922-041 | SKIDTUBE ASSEMBLY |
| 2 | | | | | 20 | | D2651-1 | * PLUG |
| 3 | | | | | 20 | | D2651-3 | * O-RING |
| 4 | | | | | 1 | | D2646 | * AFT CAP |
| 5 | | | | | 2 | | MS27039-1-08 | * SCREW |
| 6 | | | | | 2 | | AN960JD10L | * WASHER |
| 7 | | | | | 4 | | D2648-3 | * WEARPAD |
| 8 | | | | | 1 | | D2648-5 (OR D2648-3) | * WEARPAD |
| 9 | | | | | 1 | | D2656-15 | * WEARSHOE |
| 10 | | | | | 1 | | D2656-21 | * WEARSHOE |
| 11 | | | | | 1 | | D2924 | * WEARSHOE |
| 12 | | | | | 50 | | MS27039-1-08 | * SCREW |
| 13 | | | | | 50 | | AN960JD10L | * WASHER |
| 14 | | | | | 50 | | AKS7-1032-130 | * INSERT |
| 20 | 1 | | 1 | | | | D2932-1 | SADDLE OUTSIDE, LH |
| 20 | | 1 | | 1 | | | D2932-2 | SADDLE OUTSIDE, RH |
| 21 | 1 | | 1 | | | | D2933-1 | SADDLE INSIDE, LH |
| 21 | | 1 | | 1 | | | D2933-2 | SADDLE INSIDE, RH |
| 22 | 1 | | | | | | D2932-1 | SADDLE OUTSIDE, LH |
| 22 | | 1 | | | | | D2932-2 | SADDLE OUTSIDE, RH |
| 22 | | | 1 | | | | D2938-1 | SADDLE OUTSIDE, LH |
| 22 | | | | 1 | | | D2938-2 | SADDLE OUTSIDE, RH |
| 23 | 1 | | | | | | D2933-1 | SADDLE INSIDE, LH |
| 23 | | 1 | | | | | D2933-2 | SADDLE INSIDE, RH |
| 23 | | | 1 | | | | D2939-1 | SADDLE INSIDE, LH |
| 23 | | | | 1 | | | D2939-2 | SADDLE INSIDE, RH |
| 24 | 2 | 2 | 2 | 2 | | | D2934 | SADDLE SPACER |
| 25 | 2 | 2 | 2 | 2 | | | D2935 | SADDLE SPACER |
| 26 | 8 | 8 | 8 | 8 | | | AN3-41A | BOLT |
| 27 | 16 | 16 | 16 | 16 | | | D2652 | BUSHING |
| 28 | 8 | 8 | 8 | 8 | | | AN960JD10 | WASHER |
| 29 | 8 | 8 | 8 | 8 | | | MS21042-3 | NUT (OR MS21042L3) |
| 30 | 4 | 4 | 4 | 4 | | | AN5-10A | BOLT |
| 31 | 4 | 4 | 4 | 4 | | | AN5-12A | BOLT |
| 32 | 8 | 8 | 8 | 8 | | | AN960JD516 | WASHER |
| 33 | 12 | 12 | 12 | 12 | | | AN4-6A | BOLT |
| 34 | 24 | 24 | 24 | 24 | | | AN960JD416 | WASHER |
| 35 | 12 | 12 | 12 | 12 | | | MS21042-4 | NUT (OR MS21042L4) |
| 36 | 10 | 10 | 10 | 10 | | | D2712 | SET SCREW |
| 40 | 1 | 1 | 1 | 1 | | | D2707-043 (OR D2968-043) | TOW RING |
| 41 | 1 | 1 | 1 | 1 | | | AN960JD1016 | WASHER |
| 42 | 1 | 1 | 1 | 1 | | | AN970-4 | WASHER |
| 43 | 1 | 1 | 1 | 1 | | | MS21042-4 | NUT (OR MS21042L4) |
| 50 | | | | | | 2 | D3046-041 | LUG BRACKET |
| 51 | | | | | | 4 | AN3-37A | BOLT |
| 52 | | | | | | 8 | D2652 | BUSHING |
| 53 | | | | | | 4 | AN960DJ10 | WASHER |
| 54 | | | | | | 4 | MS21042-3 | NUT (OR MS21042L3) |

* DENOTES THAT PART IS INCLUDED WITH D2922-041 ASSEMBLY

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Revision: C

Date: 06.11.14

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 31292

Date: Monday, 3/19/2007 4:36:06 PM
User: Kim Johnston

Process Sheet

| | | | |
|-----------------------|--|------------------|---------------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : 0H-58 SKIDTUBE ASSEMBLY |
| Job Number | : 31292A | | |
| Estimate Number | : 10475 | | |
| P.O. Number | : N/A | Part Number | : D058672041 |
| This Issue | : 3/19/2007 | Drawing Number | : D2922 REV A1 |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : N/A | Drawing Revision | : A1 |
| Previous Run | : 31291A | Material | : N/A |
| Written By | : | Due Date | : 4/10/2007 |
| Checked & Approved By | : <i>07.03.20</i> | Qty: | 1 Um: Each |
| Comment | : Est Rev: 02.06.28 Re-format; ECN 258 KJ Est Rev: D 06.02.06 Added Dt8025 EC | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|--------------|
| Seq. #: | Machine Or Operation: | Description: |
|---------|-----------------------|--------------|

| | | |
|-----|----|------------------|
| 1.0 | DC | DOCUMENT CONTROL |
|-----|----|------------------|



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D058-672-041 CHG 001

| | | |
|-----|-------|-------------------|
| 2.0 | D2620 | Bent 206 Skidtube |
|-----|-------|-------------------|



Comment: Qty: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick

| | | | |
|-----|-------------|-------------|-------|
| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|-------|

| | | | |
|---|-------|-----------------|----------------------------|
| 1 | D2620 | Bent Tube 3" OD | <i>B 29388 BE 07-03-21</i> |
|---|-------|-----------------|----------------------------|

| | | |
|-----|----------------|-------------------------|
| 3.0 | LANDING GEAR 1 | LANDING GEAR RESOURCE 1 |
|-----|----------------|-------------------------|



Comment: LANDING GEAR RESOURCE 1

1-Debur Fwd edge of tube

BE 07-03-21

2-Weld D2794 cap as per QSI 004 and Dwg D2922. Use aluminum rod.

A/R Aluminum Rod

M103917/M102421

BE 07-03-21

3-Cut aft end of D2620 bent tube as per dwg D2922

Pm 07-03-21

4-Drill pilot holes using drill jig DT8480 and DT8025 open to 0.312" dia.

Pm 07-03-21

5-Drill holes for wearplates using DT 8487 Open to 0.297" dia.

Pm 07-03-21

6-Drill holes for aft cap as per Dwg D2922 using drill jig DT 8025. Open using #6 Drill Bit

Pm 07-03-21

8-Remove inner indexing ridge on aft end of skidtube as per Dwg D2922

Pm 07-03-22

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

Date: Monday, 3/19/2007 4:36:06 PM

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 0H-58 SKIDTUBE ASSEMBLY

Job Number: 31292A

Part Number: D058672041

Job Number:



Seq. #:

Machine Or Operation:

Description:

9-Deburr and Blow out all chips form inside the tube *pm 07-03-220*

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JD 7-3-220

5.0

D2923

Web



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2923 Web *B 31565**R 07-04-04*
R 07-04-02

6.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open holes to finished size as per Dwg D2922(without cutting fluid) *R 07-04-02*2-Countersink crossbolt spacer holes as per Dwg D2922(without cutting fluid) *R 07-04-02*3-Deburr and Blow out all chips from inside the tube *R 07-04-02*

4-Bond D2923 web in place as per QSI 015. Ensure holes lineup

A/R Sikaflex-291 *M103497*Sikaflex expire date: *07-10-01**R 07-04-03*

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/04/10

8.0

D2794

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Qty

Part Number Description

1 D2794 Fwd Cap

Batch

B14400 BE 07-03-21

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

Date: Monday, 3/19/2007 4:36:06 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 0H-58 SKIDTUBE ASSEMBLY

Job Number: 31292A

Part Number: D058672041

Job Number:



Seq. #:

Machine Or Operation:

Description:

9.0

D2649

Crossbolt Spacer



Comment: Qty.: 22.0000 Each(s)/Unit Total: 22.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

22 D2649

Crossbolt spacer

BE 31112 BE 07-04-10

10.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Weld D2649 cross bolt spacers as per QSI 004 and Dwg D2922. (Remember to back drill each hole to 0.250" before welding the other side)

A/R Aluminum Rod

M 102421 BE 070410

3-Grind welds flush as per Dwg D2922

BE 07-04-12

4-Counterbore 5/16" x 0.750" deep as per Dwg D2922

BE 07-04-12

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Mon 04/12

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Mon 04/12

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

LD 0704150

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-L 07/04/12 019

15.0

D26483

Wearpad



Comment: Qty.: 5.0000 Each(s)/Unit Total: 5.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

5 D2648-3

Wearpad

B29777

FD 07/04/19 ①

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prdd Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Monday, 3/19/2007 4:36:06 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 0H-58 SKIDTUBE ASSEMBLY

Job Number: 31292A

Part Number: D058672041

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

D265615

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

1 D2656-15 Wearshoe

Batch

B29335

17.0

D265621

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

1 D2656-21 Wearshoe

Batch

B29198

18.0

D2924

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

1 D2924 Wearshoe

Batch

B22595

19.0

MS27039108

Screw



Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

Pick:

Qty Part Number Description

50 MS27039-1-08 Screw

Batch

M102630

20.0

AN960JD10L

Washer



Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

Pick:

Qty Part Number Description

50 AN960JD10L Washer

Batch

M102832

FL 07/04/18 ①

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

Date: Monday, 3/19/2007 4:36:06 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 0H-58 SKIDTUBE ASSEMBLY

Job Number: 31292A

Part Number: D058672041

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

ALS41032130

Insert



Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

Pick:

Qty Part Number Description

Batch

50 ALS4-1032-130 Insert

or (see QSI 017)

m103495

22.0

D26511

Plug



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number Description

Batch

20 D2651-1 Plugs

B30943

23.0

D26513

O-Ring



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number Description

Batch

20 D2651-3 O-Rings

B30815

24.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

Batch

1 D2646 Aft Cap

B30119

25.0

MS27039108

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description

Batch

2 MS27039-1-08 Screw

m102630

FL 07/04/19 ①

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|--|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification ⁴ Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

Date: Monday, 3/19/2007 4:36:06 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 0H-58 SKIDTUBE ASSEMBLY

Job Number: 31292A

Part Number: D058672041

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description

2 AN960JD10L Washer

Batch:

m/02832

FOL

07/04/19 ①

27.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearpads as per dwg D2922. Insert a drop of Sikaflex at insert hole before installing wearplates.

A/R Sikaflex-291

Sikaflex expire date: 07/10

m/103497

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2922

3-Install D2646 Aft Cap and seal with Sikaflex adhesive. Clean excess adhesive

A/R Sikaflex-291

Sikaflex expire date: 07/10

m/103497

3- Wing Walk as per Dwg D2922 and QSI 005 4.4

m/103707

Batch:

07/04/20

①

28.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07-04-23 ①

29.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-04-23 ①

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PPP 31292 07/04/24

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 27/04/30

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

Date: Monday, 3/19/2007 4:36:07 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 0H-58 SKIDTUBE ASSEMBLY

Job Number: 31292A

Part Number: D058672041

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

①
F0710/30

Job Completion



U 07.04.30

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



| | | | |
|------------------------|-------------------------|--|------------------------|
| DESIGN RF | DRAWN BY RF | DART AEROSPACE USA, INC. BELLEVUE, WA | |
| CHECKED [Signature] | APPROVED [Signature] | DRAWING NO. D2922 | REV. A SHEET 1 OF 2 |
| DATE 99.10.14 | | TITLE OH-58 SKIDTUBE ASSEMBLY SCALE NTS | |
| A | 99.10.14 | NEW ISSUE | |
| A1 | # IP 01.08.20 | Ø0.640 WAS Ø0.625 | |

RELEASED
00.05.11 [Signature]

| Qty | Part Number | Description |
|-----|---|-------------------|
| X | D2922-041 | SKIDTUBE ASSEMBLY |
| * | D2600-1 | EXTRUSION |
| 1 | D2646 | AFT CAP. |
| 4 | D2648-3 | WEARPAD |
| 1 | D2648-5 | WEARPAD |
| 22 | D2649 | CROSS BOLT SPACER |
| 20 | D2651-1 | PLUG |
| 20 | D2651-3 | O-RING |
| 1 | D2656-15 | WEARSHOE |
| 1 | D2656-21 | WEARSHOE |
| 1 | D2794 | CAP |
| 1 | D2923 | WEB |
| 1 | D2924 | WEARSHOE |
| 50 | AKS7-1032-130 or AKS4-1032-130 or ALS7-1032-130 or ALS4-1032-130 | INSERT |
| 52 | AN960JD10L | WASHER |
| 52 | MS27039-1-08 | SCREW |

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) LENGTH OF D2600-1 EXTRUSION REQUIRED BEFORE BENDING = 160 INCHES.*
- 3) INSERT D2923 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015 AFTER BENDING.
- 4) USE DART DRILL TEMPLATE DT8406 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL AKS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL MS27039-1-08 SCREWS AND AN960JD10L WASHERS IN ALL INSERTS. SEAL WITH SIKAFLEX-241/291.
- 5) WELDING TO BE DONE PER DART QSI 004.
- 6) FINISH:
ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2923 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 0.50 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 7) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (20 PLACES).

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31292A

| | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|-----|
| 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | 11 | 12 | 13 | 14 | 15 | 16 | 17 | 18 | 19 | 20 | 21 | 22 | 23 | 24 | 25 | 26 | 27 | 28 | 29 | 30 | 31 | 32 | 33 | 34 | 35 | 36 | 37 | 38 | 39 | 40 | 41 | 42 | 43 | 44 | 45 | 46 | 47 | 48 | 49 | 50 | 51 | 52 | 53 | 54 | 55 | 56 | 57 | 58 | 59 | 60 | 61 | 62 | 63 | 64 | 65 | 66 | 67 | 68 | 69 | 70 | 71 | 72 | 73 | 74 | 75 | 76 | 77 | 78 | 79 | 80 | 81 | 82 | 83 | 84 | 85 | 86 | 87 | 88 | 89 | 90 | 91 | 92 | 93 | 94 | 95 | 96 | 97 | 98 | 99 | 100 |
|---|---|---|---|---|---|---|---|---|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|----|-----|

NO. 99

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name Barclay Elliott
Joint Welding Procedure Tig
Part number and Job number A5586 72041 / B31008A

TEST WELDS REQUIRED

BASE METAL Alum WELDING PROCESS Tig
Penetration Complete ☐ Partial ☒ Single Weld ☒ Double Weld ☐
Current AC ☒ DC ☐ Backing YES ☐ NO ☒

| | Position | Vertical | Down <input type="checkbox"/> | Up <input type="checkbox"/> |
|--------------|-----------------------------|--|-------------------------------|-----------------------------|
| Sheet Groove | 1G <input type="checkbox"/> | 2G <input checked="" type="checkbox"/> | 3G <input type="checkbox"/> | 4G <input type="checkbox"/> |
| Tube Groove | 1G <input type="checkbox"/> | 2G <input checked="" type="checkbox"/> | 5G <input type="checkbox"/> | 6G <input type="checkbox"/> |
| Sheet Fillet | 1F <input type="checkbox"/> | 2F <input checked="" type="checkbox"/> | 3F <input type="checkbox"/> | 4F <input type="checkbox"/> |
| Tube Fillet | 1F <input type="checkbox"/> | 2F <input checked="" type="checkbox"/> | 4F <input type="checkbox"/> | 5F <input type="checkbox"/> |

Crossbolt Spacer Welded into Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐
Penetration Pass ☒ Fail ☐
Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 07/03/20

Qualifier David Newel